

IN THE CLAIMS

1. (previously presented) A multi-layer security product, comprising:
an extrusion defined by a carrier material firmly joined to at least one plastic coating;
said at least one plastic coating being firmly extruded onto the carrier material to form a thin-gauged combination of layers and consisting of laser-active plastic material that permits subsequent personalization with a laser; and
at least one covering film laminated onto the carrier material.
2. (previously presented) The multi-layer security product of claim 1, wherein the laser-active plastic material is excited substantially by laser radiation of a specific wavelength.
3. (original) The multi-layer security product of claim 1, wherein the carrier material is comprised of paper or plastic.
4. (currently amended) The multi-layer security product of claim 1, further comprising security features, the security feature being one of a watermark and a mottled fiber ~~such as watermarks and/or mottled fibers~~ on the carrier material.
5. (previously presented) The multi-layer security product of claim 1, wherein the covering film contains laser-active material.
6. (original) The multi-layer security product of claim 1, wherein the plastic coating has embossing.
7. (previously presented) The multi-layer security product of claim 1, wherein the plastic coating is imprinted after extrusion onto the carrier material.
8. (withdrawn) A process for the production of multi-layer security products said process comprising the steps of:
providing a printable carrier material as a rolled material; a
extruding at least one plastic coating which contains laser-active pigments onto the carrier material; and

subsequently leading together highly accurately the carrier material with the plastic coating and (b) the covering film (17, 18).

9. (withdrawn) The process of claim 8, wherein the carrier material with the plastic coating is rolled material and further providing the step of unwinding the rolled material after lamination.
10. (withdrawn) The process of claim 8, further providing the step of stamping out individual blanks after the lamination with the covering film.
11. (withdrawn) The process of claim 8, further providing the step of printing the carrier material in a single-stage or multi-stage process before the coating of the carrier material with the plastic coating
12. (withdrawn) The process of claim 8, further providing the step of printing and/or embossing the plastic coating before the carrier material with the plastic coating is led together with the covering film and laminated.
13. (withdrawn) The process of claim 8, wherein the carrier material comprises paper or plastic.
14. (withdrawn) The process of claim 8, wherein the carrier material is equipped with security features, such as watermarks and/or mottled fibers.
15. (withdrawn) The process of claim 8, wherein the covering film contains laser-active pigments.
16. (withdrawn) The process of claims 8, wherein security features are produced in the plastic coating and/or the covering film by activating the laser-active pigments with laser radiation of specific wavelength matched to the laser-active pigment used.
17. (withdrawn) The process of claim 16, wherein the security features produced by laser cannot at least to some extent, be personalized.
18. (withdrawn) The process of claim 16, wherein the production of security features by laser in the plastic coating is carried out after the application of the plastic coating by extrusion and/or after the lamination of the at least one covering film.

19. (new) A multi-layer security product, the security product comprising:
- a carrier material having a first and a second side;
 - a solidified melt joined by extrusion onto the carrier material on the first side, the melt including a laser-active pigment that permits subsequent personalization with a laser; and
 - at least one covering film laminated onto one of the second side of the carrier material and the solidified rolled melt.
20. (new) A web of a security product for use in a continuous printing process, the web comprising:
- an extrusion defined by a carrier material firmly joined to at least one plastic coating;
 - said at least one plastic coating being firmly extruded onto the carrier material to form a thin-gauged combination of layers and consisting of a laser-active plastic material that permits subsequent personalization with a laser; and
 - at least one covering film laminated onto the carrier material.